

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D

AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1

REF. TCCA STC: SH92-18

REF. FAA STC: SH989NE AND SH990NE

REF. EASA STC: EASA.IM.R.S.01560 AND EASA.IM.R.S.01561

1.0 PURPOSE

This service instruction is intended for customers wishing to upgrade their existing cabin floor window from D350-567-011 Kit with a D350-567-031 Floor Window Kit. Since the two kits do not share the same rivet patterns, the D350-567-031B Kit from this service instruction replaces D350-567-031 Kit to facilitate installation without having to perform extensive rework/repair of the aircraft floor prior to installation.

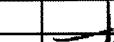
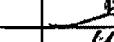
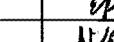
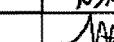
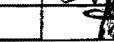
2.0 INSTALLATION CHANGE

Note: In reference with Installation Instructions D350-567, make the following substitutions:

- D3210-1B replaces D3210-1;
- D3211-1B replaces D3211-1;
- D3212-1B replaces D3212-1;
- D3213-041B replaces D3213-041.

- 2.1 Perform Steps 3.4.1 and 3.4.2 of Installation Instructions D350-567 as required.
- 2.2 Locate the D3210-1B per Figure 1 of this service instruction.
- 2.3 Determine whether to trim D3210-1B or shim the sliding door rail per Step 3.4.8 of D350-567 as required to ensure compatibility with Eurocopter Sliding Door if installed on aircraft.
- 2.4 Enlarge the viewing hole in the aircraft floor by using D3210-1B as template.
- 2.5 Transfer drill Ø0.128" holes from the aircraft floor to D3210-1B Doubler, D3211-1B Bracket, and D3212-1B Window. Drill additional holes as required through D3210-1B and aircraft floor. Ensure minimum pitch and edge distance as indicated.
- 2.6 Enlarge as required qty(4) Ø0.128" holes to Ø0.141" and drill qty(4) Ø0.141" as shown in Figure 1 of this service instruction.
- 2.7 Locate D3213-041B and transfer drill qty(12) Ø0.128" and qty(3) Ø0.141" holes from the D3210-1B Doubler/aircraft floor to the blank hinge blade of D3213-041B.
- 2.8 Complete installation in accordance with Section 3.4 of Installation Instructions D350-567.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	11.06.10
CERT. NO.:	SH92-18
ISSUE NO.:	6

A	NEW ISSUE	MB	DATE
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9561	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MOD	NTS
DATE	11.06.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PARTS LIST

Qty -031B	Part Number	Description
X	D350-567-031B	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1	D2463-0450	NEOPRENE SEAL
1	D3210-1B	DOUBLER, BLANK
1	D3211-1B	BRACKET, BLANK
1	D3212-1B	FLOOR WINDOW, BLANK
1	D3213-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
8	AN960JD6	WASHER
8	MS21042L06	NUT (OR MS21042-06)
40	MS20470AD4-5	RIVET
90	MS20470AD4-6	RIVET
20	MS20470AD4-7	RIVET

4.0 WEIGHT AND BALANCE

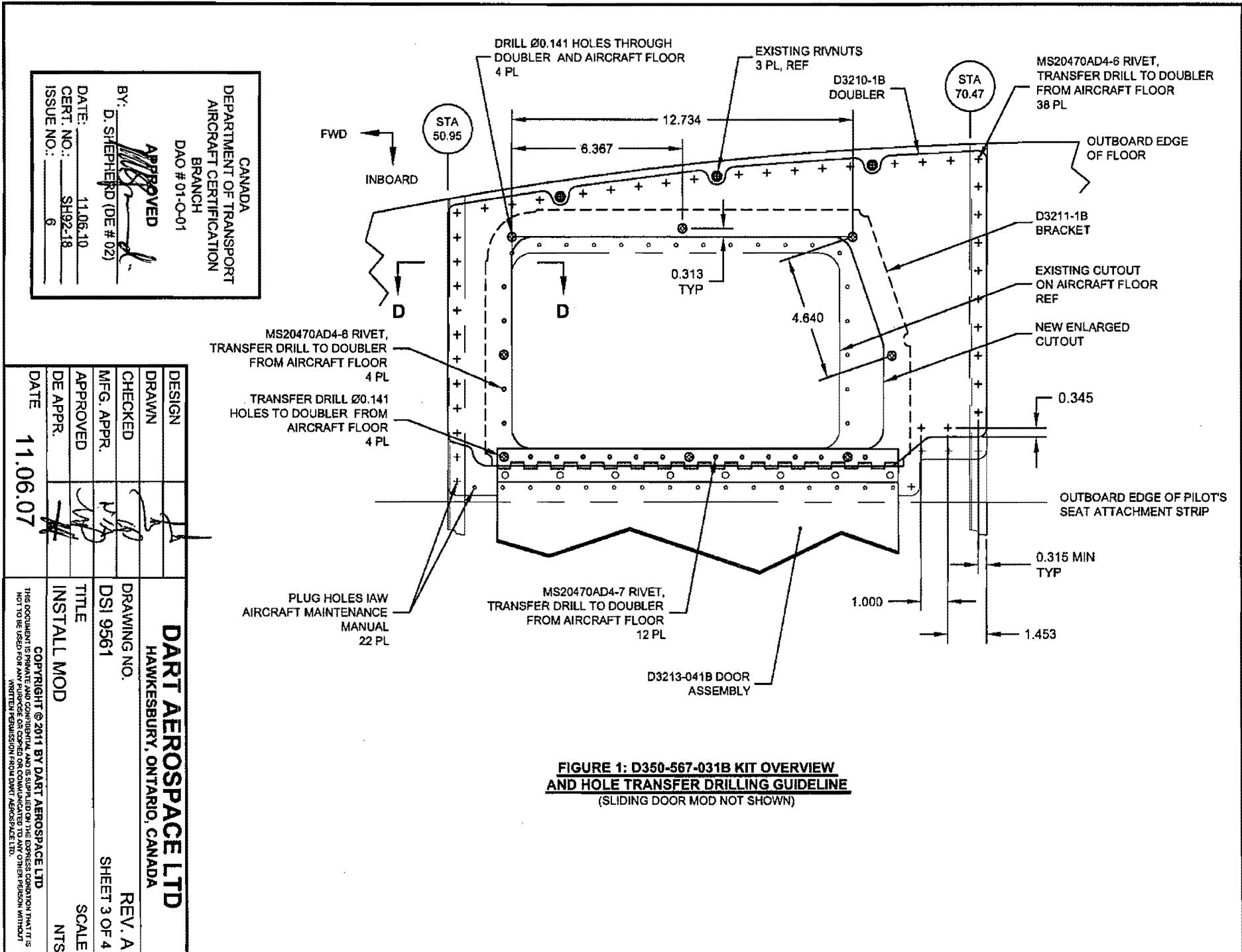
There is a negligible weight change associated with this modification. If upgrading from D350-567-011 to D350-567-117, refer to the weight and balance information for D350-567-117 of Installation Instructions D350-567.

5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS

Maintenance and continued airworthiness instructions for D350-567-031B is the same as for D350-567-031. Refer to ICA-D350-567.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	11.06.10
CERT. NO.:	SH92-18
ISSUE NO.:	6

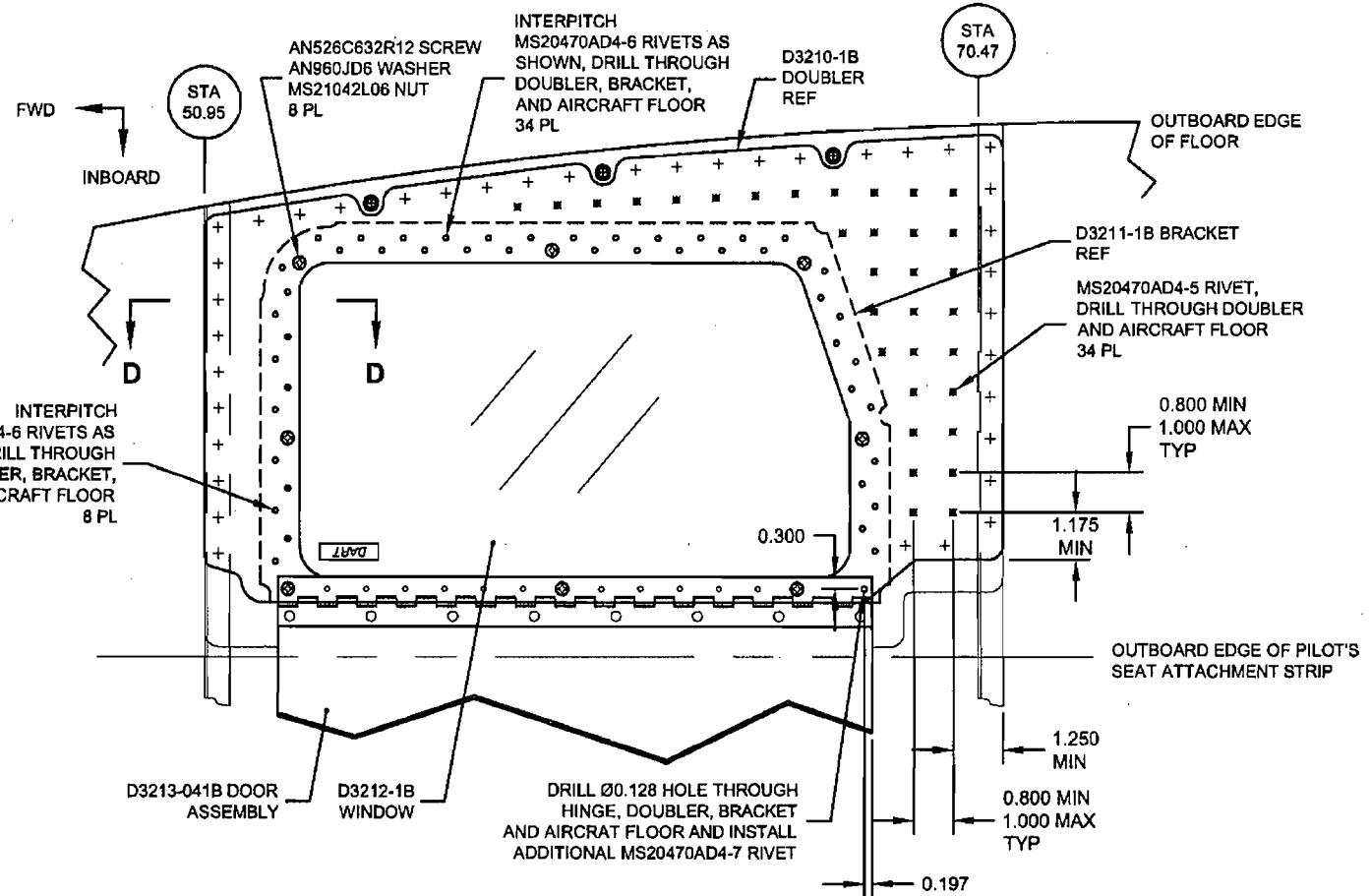
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9561	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MOD	NTS
DATE	11.06.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH	
DAO # 01-0-01	APPROVED BY: D. SHEPHERD (DE # 02)
CERT. NO.: SH92-18	DATE: 11.06.10
ISSUE NO.: 6	

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. A	
MFG. APPR.		DSI 9561	
APPROVED		SHEET 4 OF 4	
DE APPR.		SCALE	
DATE	11.06.07	NTS	

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EXPRESSLY INDICATED AS BEING FOR USE ONLY BY THE PERSON TO WHOM IT IS PROVIDED. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**FIGURE 2: TYPICAL PITCHES FOR
ADDITIONAL REQUIRED RIVETS
(SLIDING DOOR MOD NOT SHOWN)**